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D2804-042
Job Sheet 213385



Part No: D2804-042

Job Qty: 2 pcs

Part Name: RH Step Fwd Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/24/20

Job Tracking No:

Due Date: 10/12/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV D IPP F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM IPP Rev:G As per Rev C 06-11-08 JLM IPP REV:H 16.06.23 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs		10/10/20	0.00	0.14	Small Fab - 1		DAS 500 9-88 OCT 13 2020
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
110	QC 5	2 pcs		10/10/20	0.00	0.00	QC 5 - 10		DAS 81 9-89 OCT 15 2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		

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120 Powdercoat - 1 White GI(A)- B4B <i>M 254469.</i> <i>START: 2:30.</i> <i>O.V.T. 300°</i> <i>FINISH: 3:00</i>	2 pcs	10/10/20	0.00 0.10	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	<i>20-10-15</i>
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
130 QC 3	2 pcs	10/10/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	<i>DAS 81</i>
				QC 3 - 82	<i>9-89</i>
				QC 3 - 87	
				QC 3 - 47	
150 Small Fab - 2 - B4B	2 pcs	10/12/20	0.00 0.14	Small Fab - 1 - B4B	<i>DAS 58</i>
				Small Fab - 2 - B4B	<i>9-89</i>
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
160 QC 5	2 pcs	10/12/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	

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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	OCT 19 2020 DAS 40
					QC 5 - 61	9-89
					QC 5 - 81	
					QC 5 - 82	
170	Packaging 3-1 - Stock - B4B	2 pcs	10/12/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS 28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	OCT 19 2020
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180	QC 21 - SA	2 pcs	10/12/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 9	OCT 19 2020 DAS 70
					QC 21 - SA - 77	9-89
					QC 21 - SA - 28	
Part Op 100 - (Small Fab) Press D2805-2 and D2809 into arm as per Dwg D2804						
Descriptions: 110 - QC5- Inspect part completeness to step on W/O						
120 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____						
FINISH TIME: _____						
130 - QC3- Inspect Part Finish						
150 - (Small Fab) 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.						
160 - QC5- Inspect part completeness to step on W/O						
170 - Identify as per dwg & Stock Location: _____						
180 - QC21- Final Inspection - Work Order Release						

011778

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2804-2	Bracket	2 pcs (1 ea)	100-Small Fab - 1	S2S3307
D2805-2	Stop	2 pcs (1 ea)	100-Small Fab - 1	S157197
D2809	Washer	2 pcs (1 ea)	100-Small Fab - 1	3072531 S146049
AN3C16A	Bolt	4 Ea (2 ea)	150-Small Fab - 2 - B4B	S142448
D3672-15	Phenolic Washer	8 pcs (4 ea)	150-Small Fab - 2 - B4B	S142584
MS21043-3	Nut	4 Ea (2 ea)	150-Small Fab - 2 - B4B	S301302

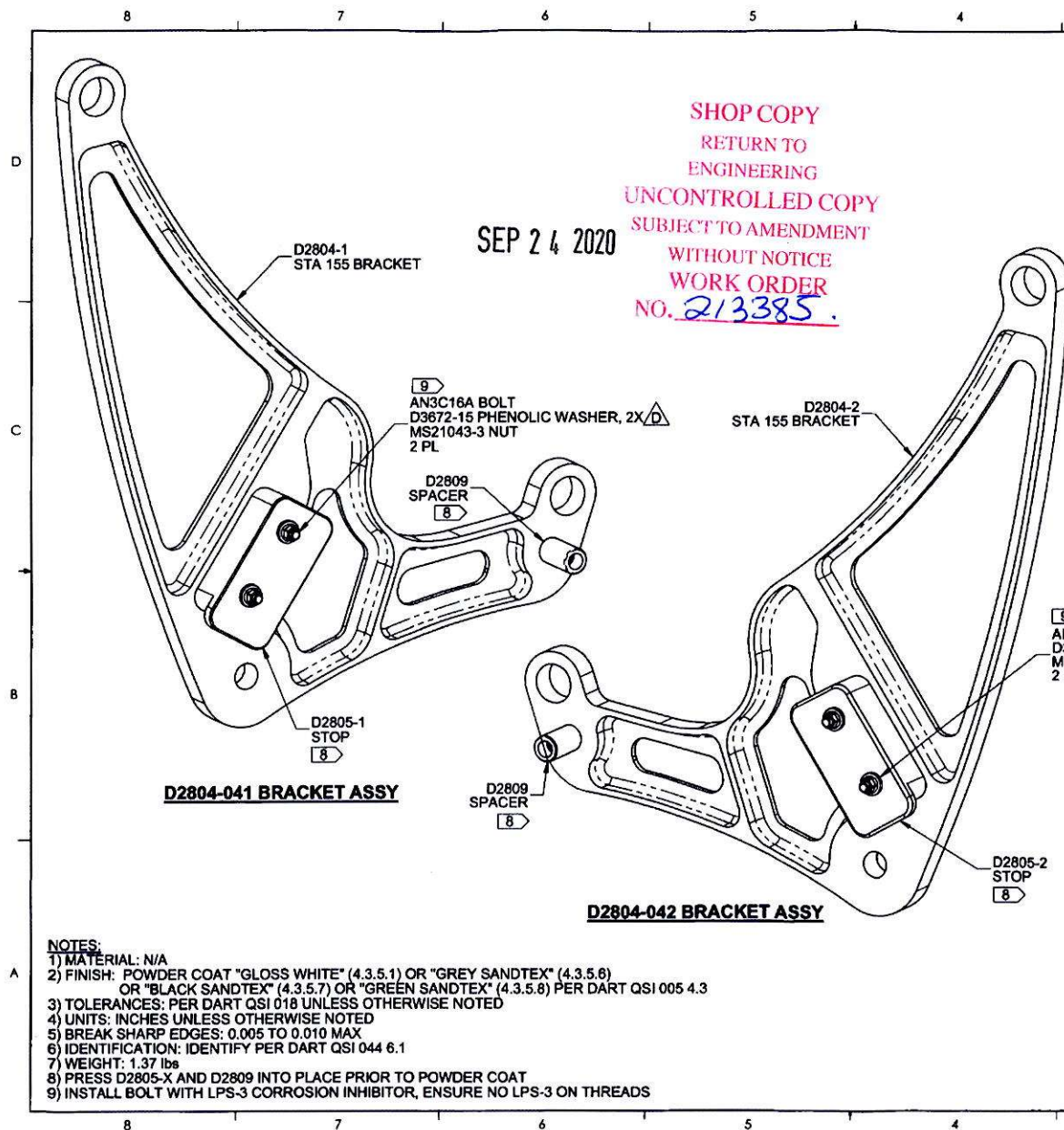
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D2804-2	2	4	0
	D2805-2	2	18	0
	D2809	2	16	0
150-Small Fab - 2 - B4B	AN3C16A	4	37	0
	D3672-15	8	275	0
	MS21043-3	4	838	0

Part Specifications

Specifications could not be found.

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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2804-041	BRACKET ASSY
		X	D2804-042	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING

RELEASED

2016 JUN 22
EKN 16-641

D	REVISE TO CURRENT FORMAT; D3672-15 WAS NAS1515H3; MS21043-3 WAS MS21042-3; ADD CSINK (SECTIONS E-E AND J-J). REF: PAR16-489. D6-314; 2.656 WAS 2.654 REASON: CAD ERROR.	MB	16.04.11
C	CHANGE GEOMETRY TO ADD CLEARANCE	CP	06.10.16
B	ADD CUTOUTS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	D9	STA 155 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S306105



Part: D2804-042

Job No: 213385

Serial No/Batch: S306105

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA

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Date: 10/13/20